












Date: Wednesday, 11/03/2009 12:58:47 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BUSHING
Job Number	: 46431		
Estimate Number	: 10175		
P.O. Number	:	Part Number	: D2570
This Issue	: 11/03/2009 S.O. No. :	Drawing Number	: D2570 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 43844	Material	:
Written By	:	Due Date	: 04/04/2009 Qty: 400 Um: Each
Checked & Approved By	: <u>JUD 09.03.11</u>		
Comment	: Est E 02.08.29 Re-format; Removed finishing; Material change K J est F 07.07.06 rev B dwg EC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M303R0750	303 Round Bar 0.750	
			
Comment: Qty.: 0.0810 f(s)/Unit Total: 32.3820 f(s) + 3.4 ft bar ends Material: Ø0.750 AISI 303 SS Rod (M303R0.750) Batch <u>110680</u> <u>09/03/13</u> <u>400 pcs</u>			
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
			
Comment: HARDINGE CNC LATHE SMALL Machine as per folio FA258 Deburr <u>09/03/13</u> <u>400 pcs</u>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>09/03/13</u> <u>400 pcs</u>			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK <u>09/03/13</u>			
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>ST36</u> <u>09/03/13</u> <u>400</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BUSHING

Job Number: 46431

Part Number: D2570

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



2400

Comment: FINAL INSPECTION/W/O RELEASE

209.03.15

Job Completion



u 29.03.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	46431
Description: Bushing		Part Number:	D2570
Inspection Dwg: D2570 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.800	+/-0.010	.802				
0.060	+/-0.005	.0615				
R0.010	+0.010/-0.000	.015				
Ø0.425	+0.000/-0.002	.423				
Ø0.257	+0.006/-0.001	.260				
Ø0.750	+/-0.010	.748				
0.030 x 20°	+/-0.010	.033 x 20°				

Measured by:	<i>[Signature]</i>	Audited by:	J.L.	Prototype Approval:	N/A
Date:	09/03/12	Date:	09/03/13	Date:	

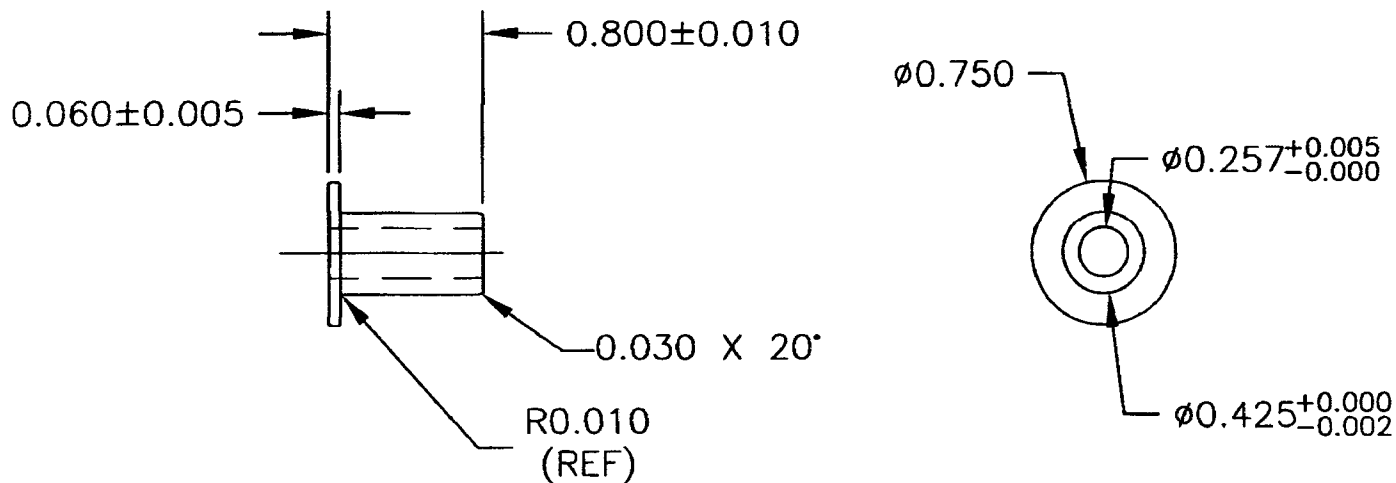
Rev	Date	Change	Revised by	Approved
A	03.12.08	New Issue	KJ/RF	
B	04.02.23	Tolerance for Ø0.425 changed	KJ/RF	
C	07.07.17	Dimensions updated per Dwg Rev. B	KJ/JLM	
D	08.07.23	Tolerance for Ø0.257 revised	KJ/DD	<i>[Signature]</i>

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2570	REV. B SHEET 1 OF 1
DATE 07.04.17		TITLE BUSHING	SCALE 1:1
A	96.09.16	NEW ISSUE	
B	07.04.17	UPDATE NOTES	

RELEASED
01.06.28

w/o 4643/

**D2570 BUSHING****D2570 BUSHING**

- 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL UNMARKED SHARP EDGES TO 0.010 MAX

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